

Date: Monday, 8/21/2006 2:12:12 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
<b>Job Number</b> : 28262	
<b>Estimate Number</b> : 10833	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D29331
<b>This Issue</b> : 8/21/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2933 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 27411	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 9/20/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est: B00.06.26 New DWG rev (mpp 2069) EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Issue material from stock: 7075-T7351 QQ-A-250/12  
Cut Size 2.0 x 6.25 X 6.00  
Grain Along Long 6.00 Length  
Batch No: 25344

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
Program part number and batch number.  
1-Inspect part number and batch number are programmed correctly.  
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
5-Deburr

J.L. 06/09/08

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
Machine Keyway and inspect per attached dimension sheet

J.L. 06/09/08

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

J.L. 06/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/09/14

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 8/21/2006 2:12:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 28262

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/08 + 8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/09/09 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.m 06-09-12 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 06 09 12 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5475

As 06/09/14 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

02/09/14 (8)

Job Completion



W 06/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28262
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.121	.121	.121		
B	0.100	0.140		.120	.121	.121	.121		
C	0.100	0.140		.129	.129	.125	.128		
D	0.210	0.230		.221	.221	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.238	.238	.239		
N	0.100	0.140		.120	.121	.121	.120		
O	0.540	0.560		.550	.549	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.251	.250	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.135	1.134	1.134	1.134		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/09/07

Audited by:	E
Date:	06/09/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28262
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.120	.122	.121		
B	0.100	0.140		.121	.120	.122	.120		
C	0.100	0.140		.126	.125	.126	.125		
D	0.210	0.230		.220	.220	.220	.221		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	/		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.237	.239	.238		
N	0.100	0.140		.121	.121	.121	.121		
O	0.540	0.560		.550	.551	.550	.549		
P	0.490	0.510		.499	.500	.500	.500		
Q	3.715	3.725		3.719	3.720	3.720	3.719		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.250	.251	.249		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/09/07

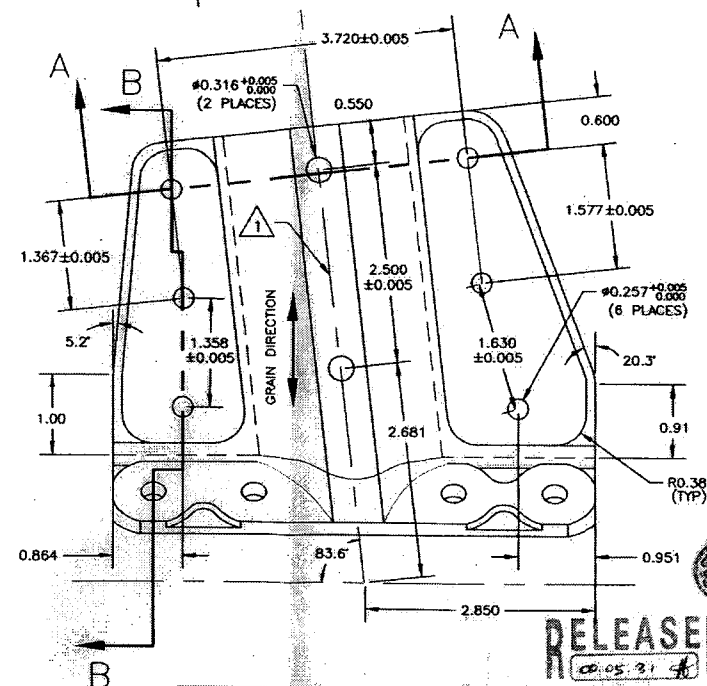
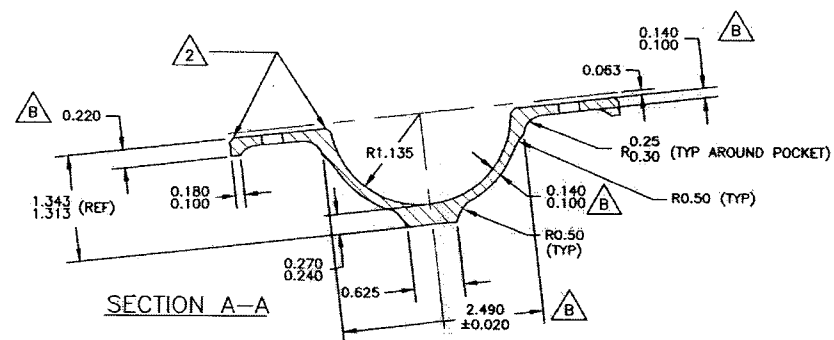
Audited by:	E
Date:	06/09/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#







MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 
- SECTION B-B
- R 0.25  
0.30 (TYP)
- R0.50  
(TYP)
- R1.575
- 0.140  
0.100 △B
- 1.000
- 0.510<sup>+0.005</sup>/<sub>0.000</sub>
- 0.500
- 0.115
- 0.240  
0.235 △B
- R0.025
- 1.605<sup>+0.005</sup>/<sub>0.000</sub>
- 48.0°
- C
- C



RELEASED  
00:05:31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY RF	 <b>DART AEROSPACE USA, INC.</b> BELLVILLE, WA
CHECKED 	APPROVED 	
DATE 00.05.29		DRAWING NO. <b>D2933</b> TITLE <b>SADDLE INSIDE</b> SCALE SHEET 1 OF 2

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